



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2563

Job Sheet 178467



Part No: D2563

Job Qty: 4 ea

Part Name: Step Weldment Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/31/18

Job Tracking No:

Due Date: 6/25/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP Rev:G 02.07.31 Re-format Location RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		6/25/18	0.00	0.00	Start Up Large Fab-2		SLG
100	Large Fab	4 pcs		6/25/18	0.00	5.88	Large Fab 2		SLG
110	QC	4 pcs		6/25/18	0.00	0.00	QC9		SLG
120	QC	4 pcs		6/25/18	0.00	0.00	QC5		SLG
130	HandFinish	4 pcs		6/25/18	0.00	1.07	HandFinish1		DR 18-08-14
140	QC	4 pcs		6/25/18	0.00	0.00	QC7		38
150	Large Fab	4 pcs		6/25/18	0.00	5.88	Large Fab 2		SLG
160	QC	4 pcs		6/25/18	0.00	0.00	QC10		SLG
170	QC	4 pcs		6/25/18	0.00	0.00	QC5		SLG
175	HandFinish	4 pcs		6/25/18	0.00	1.07	HandFinish2		SLG 18-08-14
180	Powdercoat	4 pcs		6/25/18	0.00	0.67	Powdercoat1		all 18-08-14
190	HandFinish	4 pcs		6/25/18	0.00	1.07	HandFinish3		DEB 18-08-15
200	QC	4 pcs		6/25/18	0.00	0.00	QC3		38
210	Packaging	4 pcs		6/25/18	0.00	0.00	Packaging3		6 AUG 16 2018
220	QC21-SA	4 Ea		6/25/18	0.00	0.00	QC21		9-99 21 AUG 16 2018

Part Op 100 - 1-Cut D2244 to 89.70" at 34 deg as per dwg D2563 2-Deburr ends 3-Weld (1 END CAP, LUG PLATES & Descriptions: MOUNTING ANGLE) as per dwg D2563 using DT 8343 4- Grind

150 - 1-Inspect for foreign object per QSI 024 2-Weld Remaining End cap as per Dwg D2563 using DT 8343 3-Grind

175 - Touch up Alodine as per QSI005

180 - Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 START TIME: 8:00A -

wing work 5098120

3204

8:30AM

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	4 Ea (1 ea)	90-Start up Operation	B164533
D2561	Lug	8 Ea (2 ea)	90-Start up Operation	5068735
D2564	Mounting Angle	8 Ea (2 ea)	90-Start up Operation	5084940
D2673-34	End Plate	4 Ea (1 ea)	90-Start up Operation	5078839
D2673-34	End Plate	4 Ea (1 ea)	150-Large Fab	5078839

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2244-116	4	92	0
	D2561	8	22	0
	D2564	8	1	0

#4811

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

150-Large Fab	D2673-34	4	21	0
	D2673-34	4	21	0

Part Specifications

Specifications could not be found.

Plex 5/31/18 2:55 PM Dart.lajeunesse.marie



Container No: S098421



Part: D2563

Job No: 178467

Serial No/Batch: S098421

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/01/18

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					